



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW1805G01731-3G

Job Sheet 172691



Part No: RBW1805G01731-3G

Job Qty: 3 ea

Part Name: Mast Vibration Absorber Removal Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/21/18

Job Tracking No:

Due Date: 2/28/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG RBW1805G01731-3G REV 3 IPP REV A 18.02.16 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		2/27/18	0.00	0.00	Start Up Small Fab-4		MLC
100	Small Fab	3 pcs		2/28/18	0.00	3.00	Small Fab-9		MLC
110	QC	3 pcs		2/28/18	0.00	0.00	QC5		RB
130	Packaging	3 pcs		2/28/18	0.00	0.00	Packaging3-2		APR 26 2018
140	QC21-FG	3 Ea		2/28/18	0.00	0.00	QC21		GA 107

Part Op 100 - 1- Assemble as per DWG RBW1805G01731-3G
Descriptions: 130 - Identify and Stock

DAS
21
3-00

APR 26 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91590A117	External Snap Ring .375	30 (10 ea)	90-Start up Operation	5048567
94355A227	TBD	30 (10 ea)	90-Start up Operation	5048566
RBW1805G01731-3G-1	Top Plate	3 Ea (1 ea)	90-Start up Operation	
RBW1805G01731-3G-3	Jack Plate	3 Ea (1 ea)	90-Start up Operation	5058507
RBW1805G01731-3G-5	Button	24 Ea (8 ea)	90-Start up Operation	5063702
RBW1805G01731-3G-7	Jacking Screw	24 Ea (8 ea)	90-Start up Operation	5063852
RBW1805G01731-3G-9	Pull Screw	30 Ea (10 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	91590A117	30	0	0
	94355A227	30	0	0
	RBW1805G01731-3G-1	3	0	0
	RBW1805G01731-3G-3	3	0	0
	RBW1805G01731-3G-5	24	0	0
	RBW1805G01731-3G-7	24	0	0
	RBW1805G01731-3G-9	30	0	0

Part Specifications

Specifications could not be found.

Plex 2/21/18 11:50 AM Dart.Gagnon.Michelle



Container No: S065565



Part: RBW1805G01731-3G

Job No: 172691

Serial No/Batch: S065565

Revision: 3

Inspector:

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www.dartaerospace.com

Date: 04/26/18

This diagram shows an exploded view of a mechanical assembly. The components are labeled with callouts as follows:

- 1**: A circular base plate with a central hole and a ring of mounting holes.
- 3**: A circular plate with a central hole and a ring of mounting holes, positioned below the base plate.
- 5**: 8X small cylindrical pins or spacers.
- 7**: 8X long cylindrical pins or spacers.
- 9**: 10X a single long cylindrical pin or spacer.
- 11**: 10X a small cylindrical pin or spacer.
- 13**: 10X a small cylindrical pin or spacer.

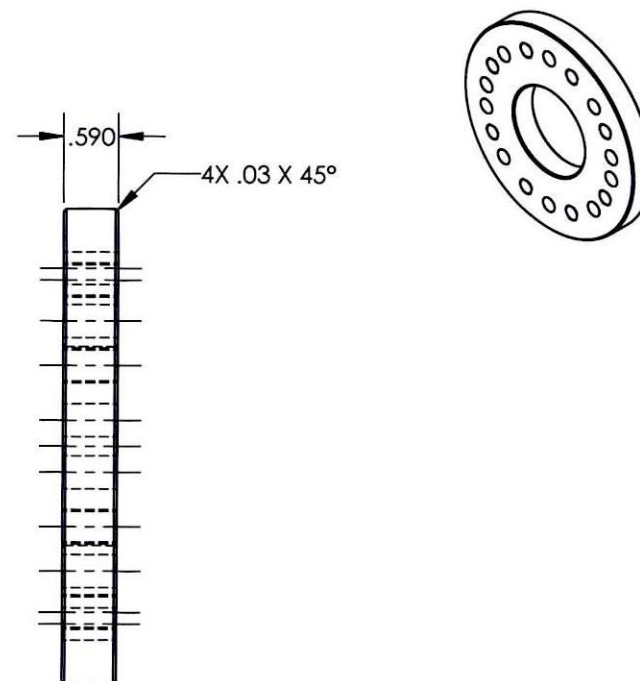
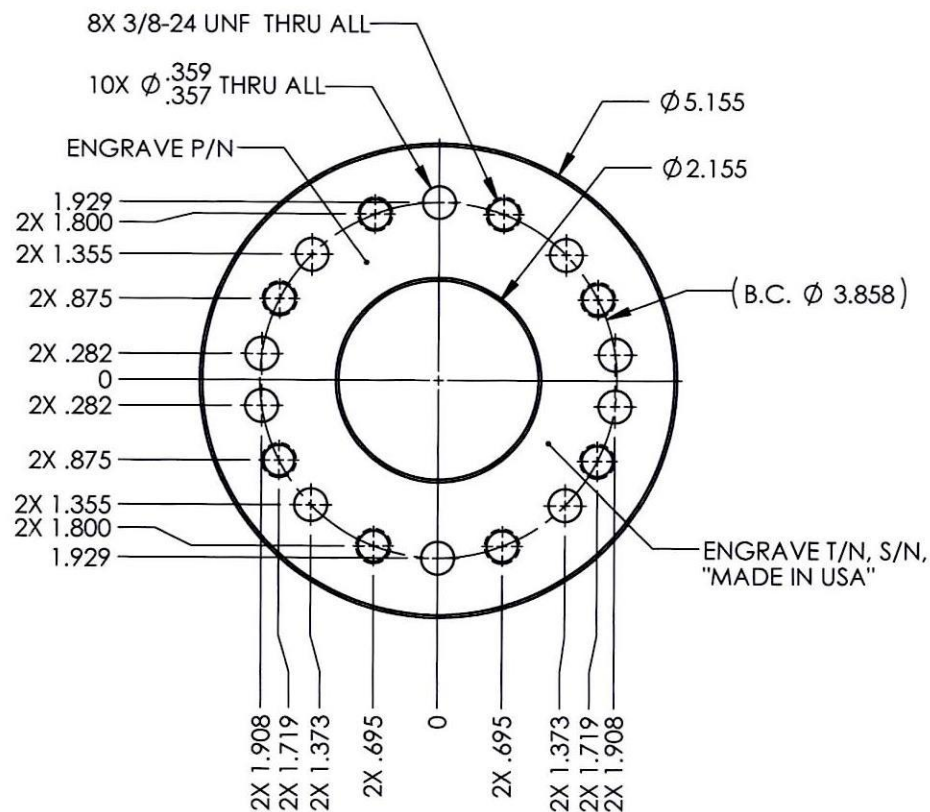
Dashed lines indicate the alignment and assembly path for the components.

Technical drawing of a bolt. A dimension line with arrows at both ends indicates a length of .27.

			
TITLE			
MVA REMOVAL TOOL			
DWG NO.			REV
RBW1805G01731-3G			3
MATERIAL		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
		.X ± .1 SURFACES = 125/√	
DRAWN BY:	SMITH	1. BREAK ALL SHARP EDGES	
CHECKED:	DD 06/22/2017	.015 x 45° OR .015R	
OPPS APPR:	AA 06/26/2017	2. DIMENSIONAL LIMITS APPLY	
QA APPR:	JL 06/28/2017	AFTER PLATING	
APPROVED:	JAG 07/03/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
		USED ON MODEL	
		AW139	
SCALE	1:4	DATE	4/25/2013
		SHEET 1 OF 6	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0288	-1 CH'D DIM WAS Ø.355 THRU IS Ø.3564-.3555 THRU.	9/2/2015	RJC	JAG
3	17-0143	-1 CH'D DIM'S WAS 10X Ø.3564/.3555 THRU IS 10X Ø.359/.357 THRU ALL, WAS 1.800 IS 2X 1.800, WAS 1.355 IS 2X 1.355, WAS .875 IS 2X .875, WAS .282 IS 2X .282, WAS .282 IS 2X .282, WAS .875 IS 2X .875, WAS 1.355 IS 2X 1.355, WAS 1.800 IS 2X 1.800, WAS 1.908 IS 2X 1.908, WAS 1.719 IS 2X 1.719, WAS 1.373 IS 2X 1.373, WAS .695 IS 2X .695, WAS .695 IS 2X .695, WAS 1.373 IS 2X 1.373, WAS 1.719 IS 2X 1.719, WAS 1.908 IS 2X 1.908. CH'D ENGRAVE NOTE WAS ENGRAVE P/N: "RBW1805G03351-3G" IS ENGRAVE P/N.	6/19/2017	RJC	JAG

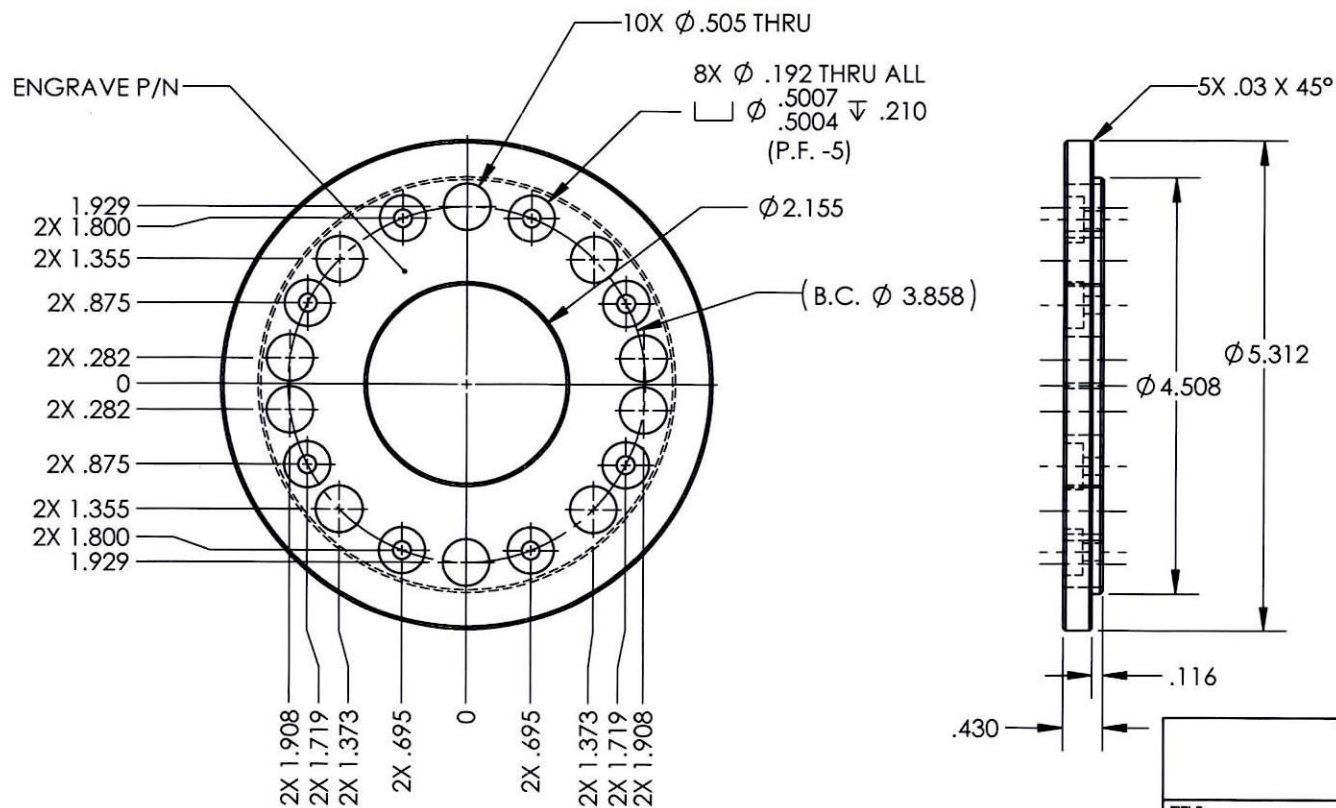


①
TOP PLATE

DART AEROSPACE	
TITLE MVA REMOVAL TOOL	
DWG NO. RBW1805G01731-3G-1	REV 3
MAT'L S.S.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: RJC 06/19/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 06/22/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 06/26/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 06/28/2017	USED ON MODEL
APPROVED: JAG 07/03/2017	AW139
SCALE 1:2	DATE 6/19/2017
SHEET 2 OF 6	

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
3	17-0143	-3 CH'D DIM'S WAS 8X Ø.192 THRU ALL L. Ø.500 ▽.210 IS 8X Ø.192 THRU ALL L. Ø.5007/.5000 ▽.210 (P.F.-5). WAS 1.800 IS 2X 1.800, WAS 1.355 IS 2X 1.355, WAS .875 IS 2X .875, WAS .282 IS 2X .282, WAS .282 IS 2X .282, WAS .875 IS 2X .875, WAS 1.355 IS 2X 1.355, WAS 1.800 IS 2X 1.800, WAS 1.908 IS 2X 1.908, WAS 1.719 IS 2X 1.719, WAS 1.373 IS 2X 1.373, WAS .695 IS 2X .695, WAS .695 IS 2X .695, WAS 1.373 IS 2X 1.373, WAS 1.719 IS 2X 1.719, WAS 1.908 IS 2X 1.908. CH'D ENGRAVE NOTE WAS ENGRAVE P/N: :RBW1805G03031-3G" IS ENGRAVE P/N.	6/19/2017	RJC	JAG	



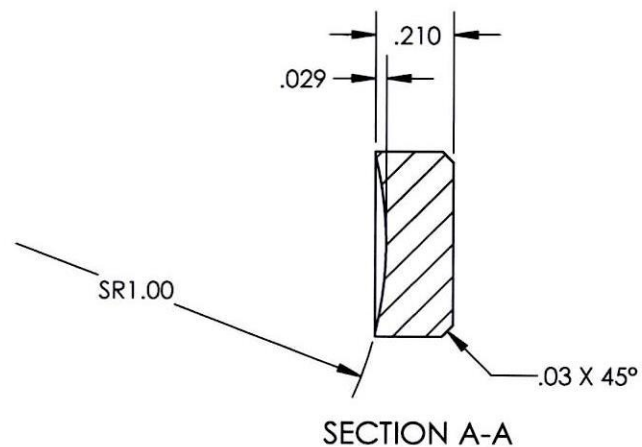
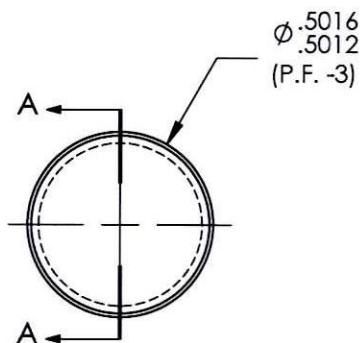
(-3)

JACK PLATE

DART AEROSPACE	
TITLE MVA REMOVAL TOOL	
DWG NO. RBW1805G01731-3G-3	REV 3
MAT'L S.S.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FEAT	.XXX ± .005 FRACTIONS ± 1/8
TREAT	.XX ± .01 ANGLES ± 5°
FINISH	.X ± .1 SURFACES = 125
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: RJC 06/19/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DD 06/22/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 06/26/2017	USED ON MODEL
QA APPR: JL 06/28/2017	AW139
APPROVED: JAG 07/03/2017	
SCALE 1:2	DATE 6/19/2017 SHEET 3 OF 6

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0288	-5 CH'D MATERIAL CALLOUT WAS 4140 IS 4140/4142.	9/2/2015	RJC	JAG
3	17-0143	-5 CH'D DIMS WAS Ø.500 IS Ø.5016/.5012 (P.F. -3), WAS R1.00 IS SR1.00. ADDED DIM .03 X 45°.	6/19/2017	RJC	JAG

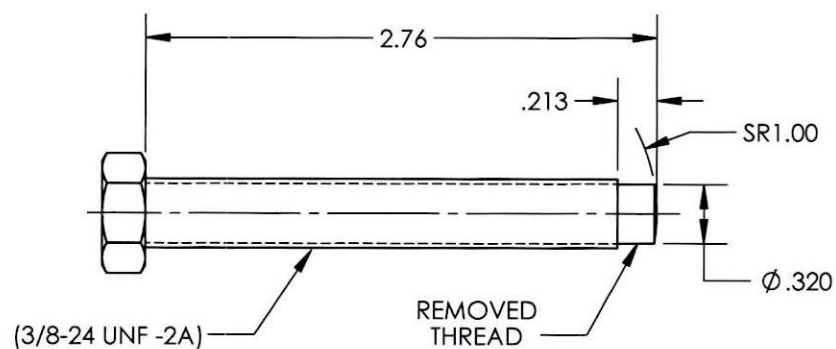
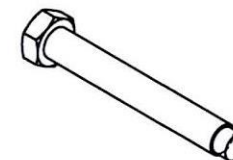


(-5)
BUTTON

DART AEROSPACE	
TITLE MVA REMOVAL TOOL	
DWG NO. RBW1805G01731-3G-5	REV 3
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT HRC 50-55	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/16
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± 5°
DRAWN BY: RJC 06/19/2017	.X ± .1 SURFACES ± 125/
CHECKED: DD 06/22/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 06/26/2017	.015 x 45° OR .015R
QA APPR: JL 06/28/2017	2. DIMENSIONAL LIMITS APPLY
APPROVED: JAG 07/03/2017	AFTER PLATING
SCALE 2:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 6/19/2017	USED ON MODEL
SHEET 4 OF 6	AW139

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	17-0143	-7 DELETED DIMS 2.75, .200. ADDED DIM'S 2.76, .213, SR 1.00.	6/19/2017	RJC	JAG



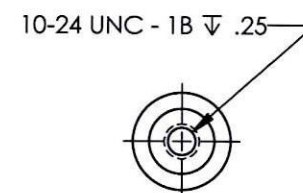
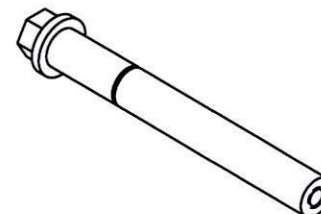
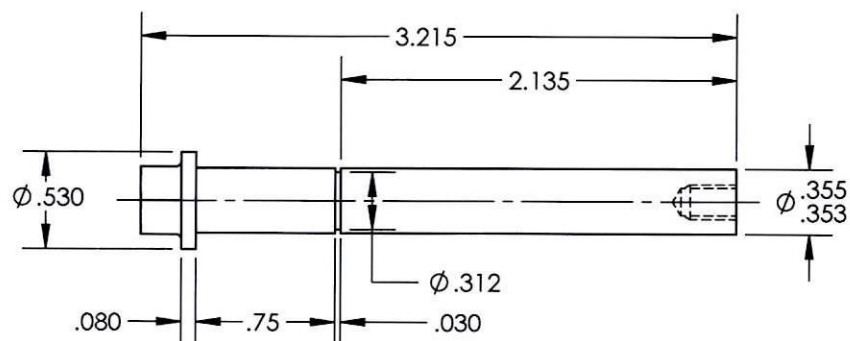
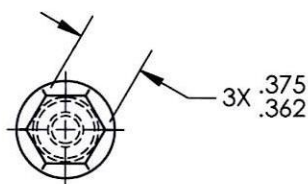
(-7)

JACKING SCREW

DART AEROSPACE	
TITLE MVA REMOVAL TOOL	
DWG NO. RBW1805G01731-3G-7	REV 3
MAT'L S.S.	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/√
DRAWN BY: RJC 06/19/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 06/22/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 06/26/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 06/28/2017	USED ON MODEL
APPROVED: JAG 07/03/2017	AW139
SCALE 1:1	DATE 6/19/2017 SHEET 5 OF 6

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0288	-9 CH'D DIM'S WAS 10-24 UNC ∇ .125 IS 10-24 UNC ∇ .25, WAS $\varnothing$.355 IS $\varnothing$.3550-.3544.	9/2/2015	RJC	JAG
3	17-0143	-9 CH'D DIM WAS .375 IS 3X .375/.362, WAS $\varnothing$.3550/.3544 IS .355/.353, WAS (.750) IS .75.	6/19/2017	RJC	JAG



(-9)

PULL SCREW

DART AEROSPACE	
TITLE MVA REMOVAL TOOL	
DWG NO. RBW1805G01731-3G-9	REV 3
MAT'L S.S.	UNLESS OTHERWISE SPECIFIED
HEAT	DIMENSIONS ARE IN INCHES
TREAT	.XXX $\pm$.005 FRACTIONS $\pm$ 1/8
FINISH	.XX $\pm$.01 ANGLES $\pm$ 5°
SPEC	.X $\pm$.1 SURFACES = 125/
DRAWN BY: RJC 06/19/2017	1. BREAK ALL SHARP EDGES
CHECKED: DD 06/22/2017	.015 x 45° OR .015R
OPPS APPR: AA 06/26/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 06/28/2017	AFTER PLATING
APPROVED: JAG 07/03/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:1	USED ON MODEL
DATE 6/19/2017	AW139
SHEET 6 OF 6	